



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2435
Job Sheet 202737


Part No: D2435

Job Qty: 12 pcs

Part Name: Bearpaw



Part Weight: 0 lbs

Job Created: 11/1/19

Due Date: 11/28/19

Type: Stock

Note: DWG REV E1

Ship Via:

Status: New

Priority: Medium

Job Tracking No:

Created By: Linda Lacelle

Description:

Bill of Materials

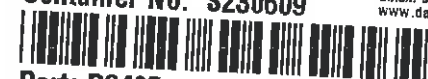
Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
90	Purchasing	12 pcs		11/28/19	0.00	0.00	Purchasing - 1			 NOV 11 2019
							Purchasing - 2			
							Purchasing - 3			
100	Packaging 2-1 - Receive - B4B	12 pcs		11/28/19	0.00	0.00	Packaging 2 - 1 - B4B			 NOV 11 2019
							Packaging 2 - 2 - B4B			
							Packaging 2 - 3 - B4B			
							Packaging 2 - 5 - B4B			
							Packaging 2 - 4 - B4B			
							Packaging 2 - 6 - B4B			
							Packaging 2 - 7 - B4B			
							Packaging 2 - 8 - B4B			
							Packaging 2 - 9 - B4B			
							Packaging 2 - 10 - B4B			
							Packaging 2 - 11 - B4B			
							Packaging 2 - 12 - B4B			
							Packaging 2 - 13 - B4B			
							Packaging 2 - 14 - B4B			
							Packaging 2 - 15 - B4B			
							Packaging 2 - 16 - B4B			
							Packaging 2 - 17 - B4B			
							Packaging 2 - 18 - B4B			
							Packaging 2 - 19 - B4B			
							Packaging 2 - 20 -			



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S230609



Part: D2435

Job No: 202737

Serial No/Batch: S230609

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/11/19

					B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
110 QC 6	12 pcs	11/28/19	0.00 0.00		QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	
					QC 6 - 40	
					QC 6 - 81	
130 HAAS 4 Axis - B4B	12 pcs	11/28/19	1.00 12.17		HAAS - 1 - B4B	
					HAAS - 2 - B4B	
					HAAS - 3 - B4B	
					HAAS - 4 - B4B	
150 QC 8	12 pcs	11/28/19	0.00 0.00		QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	

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NOV 12 2019

19/11/23

mx 19/11/25

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NOV 12 2019

19/11/23

19/11/25

				QC 8 - 47		
				QC 8 - 40		
				QC 8 - 52		
				QC 8 - 23		
				QC 8 - 57		
				QC 8 - 76		
				QC 8 - 61		
151	Packaging 3-1 - Stock - B4B	12 pcs	11/28/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	DAS
					Packaging 3 - 6 - B4B	28
					Packaging 3 - 7 - B4B	9-89
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 -	
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				B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	12 pcs	11/28/19	0.00 0.00	QC 21 - SA - 21	DAS NOV 28 2019 21 3.00
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 90 - 1-Issue PO: <u>44981</u> 2-Cut blanks as per D2435 file.					
Descriptions: 100 - (Pac2-Receive & Inspect for Damage & Mat'l Certs.)					
110 - (QC6- All purchased or subcontracted products)					
130 - (HAAS CNC vertical machine #1) 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435					
150 - (QC8- Inspect parts - second check)					
151 - (Identify as per dwg & Stock Location: _____)					
190 - (QC21- Final Inspection - Work Order Release)					
ST445					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2435P	Bearpaw	12 (1 ea)	90-Purchasing	S-230585	
MUHMWB10	UHMW 1" Black - 48"x120" Tivar Mfg.#52480104	38.4000 sf (3.2 ea)	90-Purchasing	J228711	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
90-Purchasing	D2435P	12	0	0	
	MUHMWB10	38	666	0	

Part Specifications					
Spéc No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bearpaw	0.063Inches + 0.030 - 0.010	0.093 0.053	0.063	
2	Bearpaw	45.000Degrees ± 0.030 + 5°	45.030 44.970	45° Angle	
3	Bearpaw	5.500Inches ± 0.030	5.530 5.470	5.500	
4	Bearpaw	0.200Inches ± 0.030	0.230 0.170	0.200	
5	Bearpaw	0.250Inches ± 0.010	0.260 0.240	0.250 Radius	
6	Bearpaw	0.250Inches ± 0.030	0.280 0.220	0.260	
7	Bearpaw	0.625Inches ± 0.030	0.655 0.595	0.640	
8	Bearpaw	0.250Inches ± 0.010	0.260 0.240	0.250	
9	Bearpaw	45.000Degrees ± 0.000	45.000 45.000	45° Angle	
10	Bearpaw	0.375Inches ± 0.010	0.385 0.365	0.383	
11	Bearpaw	19.000Inches ± 0.030	19.030 18.970	19.000	
12	Bearpaw	0.950Inches + 0.030 - 0.010	0.980 0.940	0.960	
13	Bearpaw	0.260Inches + 0.005 - 0.000	0.265 0.260	0.260 Diameter	
14	Bearpaw	0.930Inches ± 0.030	0.960 0.900	0.930 Diameter	
15	Bearpaw	0.300Inches + 0.030 - 0.000	0.330 0.300	0.310	
16	Bearpaw	0.375Inches ± 0.030	0.405 0.345	0.375	
17	Bearpaw	7.375Inches ± 0.030	7.405 7.345	7.375	
18	Bearpaw	4.250Inches ± 0.010	4.260 4.240	4.250	
19	Bearpaw	2.000Inches ± 0.030	2.030 1.970	2.000	
20	Bearpaw	9.000Inches ± 0.010	9.010 8.990	9.000	
21	Bearpaw	15.750Inches ± 0.030	15.780 15.720	15.750	



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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044981



Supplier: ACI002-VC
Acier Duval Steel
5888 Country Road 17
Plantagenet
ON
K0B 1L0 Canada
Phone: 613-673-5474
Fax: 613-673-4576

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044981
PO Date: 11/1/19
Due Date: 11/15/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground
Pymt Terms: Net 30
Freight Terms: Prepaid
Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	202736	D2432P	D2432 Rev H			Bearpaw 19" X 24" - cut blanks as per D2432_NEST7 file	Firmed X24		11/15/19	24 Ea	0 Ea	24 Ea	\$35.26/Ea	\$846.24
													NOV 11 2019	
2	202735	D2432P	D2432 Rev H			Bearpaw 19" X 24" - cut blanks as per D2432_NEST7 file	Firmed X24		11/18/19	24 Ea	0 Ea	24 Ea	\$35.26/Ea	\$846.24
													NOV 11 2019	
3	202734	D4355-1P	D4355 Rev B			Bearpaw - cut blanks as per D4355-1 file	Firmed X6		11/15/19	6 Ea	0 Ea	6 Ea	\$44.88/Ea	\$269.28
													NOV 11 2019	
4	202733	D4930-3P	D4930 Rev B			Bearpaw - cut blanks as per D4930-3 file	Firmed X8		11/15/19	8 Ea	0 Ea	8 Ea	\$25.61/Ea	\$204.88
													NOV 11 2019	
5	202732	D4930-1P	D4930 Rev B			Bearpaw - cut blanks as per D4930-1 file	Firmed X4		11/15/19	4 Ea	0 Ea	4 Ea	\$23.09/Ea	\$92.36
													NOV 11 2019	
6	202731	D5377-1P	D5377 Rev A			Bearpaw - cut blanks as per D5377-1 file	Firmed X8		11/15/19	8 Ea	0 Ea	8 Ea	\$48.89/Ea	\$391.12
													NOV 11 2019	
7	202742	D4353-041P	D4353 Rev B			Bearpaw - cut blanks as per D4353-041 file	Firmed X10		11/15/19	10 Ea	0 Ea	10 Ea	\$42.68/Ea	\$426.80
													NOV 11 2019	

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Tel (613) 632-5200

PURCHASE ORDER

POHB044981



Items														
Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	202741	D2521P	D2521 Rev A			Individual Bearpaw - cut blanks as per D2521_BLANK file	Firmed X14	-	11/15/19	14 Ea	0 Ea	14 Ea	\$57.77/Ea	\$808.78
											NOV 11 2019			
9	202740	D4297-1P	D4297 Rev C			Bearpaw - cut blank as per D4297-1 file	Firmed X6	-	11/15/19	6 Ea	0 Ea	6 Ea	\$33.18/Ea	\$199.08
											NOV 11 2019			
10	202737	D2435P	D2435 Rev E1			Bearpaw - cut blank as per D2435 file	Firmed X12	-	11/15/19	12 Ea	0 Ea	12 Ea	\$26.45/Ea	\$317.40
											NOV 11 2019			
Grand Total:														\$4,402.18

Order Notes

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A016 PERSONNEL QUALIFICATION

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A032 DOCUMENT SPECIAL REQUIREMENTS

A033 STATEMENT OF CONFORMITY/TEST RECORDS FOR NAS, AN and MS FASTENERS

A040 NOTIFICATION OF QUALITY ESCAPE

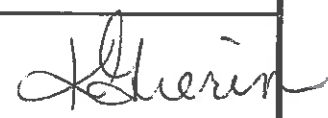
A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENTS

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS



Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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Acier Duval Steel div. JD Welding Inc.
5888 County Road 17, Plantagenet ON. K0B1L0
Tel: 613-673-4574 ~~~ toll free\ sans frais 1-866-831-5722
info@adsindustries.com www.adsindustries.com

Certificate of Conformance (CoC)

Customer Name Dart Aerospace
P.O. Number POHB044981
Part Number D2435P (Job : 202737)
Drawing Number D2435 Rev E1
Material thickness 1"
Quantity 12
Invoice \ Packing slip # 8123

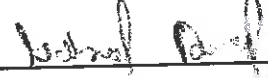
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All technical requirements of the contract are satisfied. Quality and performance are in accordance with the contract, the specifications, and all references and associated contractual drawing and document

I, as a supplier to Dart Aerospace, acknowledge and certify the material covered under this document is produced in accordance with the following:

The Quantity in the P.O
The Drawing send to the administration
And other document send in regard to the pieces
*(Acknowledge by marking the boxes)

☒
☒
☒

	Quality Management	November 7 2019
Signature	Title	Date

This certifies the parts / items / material identified above conform to all applicable drawing and/or specification as evidenced by report or other documentation on file and all other purchase order and

Acier, Duval Steel

Atelier de fabrication: aluminium et acier inoxydable
Service de coupage, pliage, roulage et polissage.

1-866-831-5722
T: 613-673-4574
info@adsindustries.com

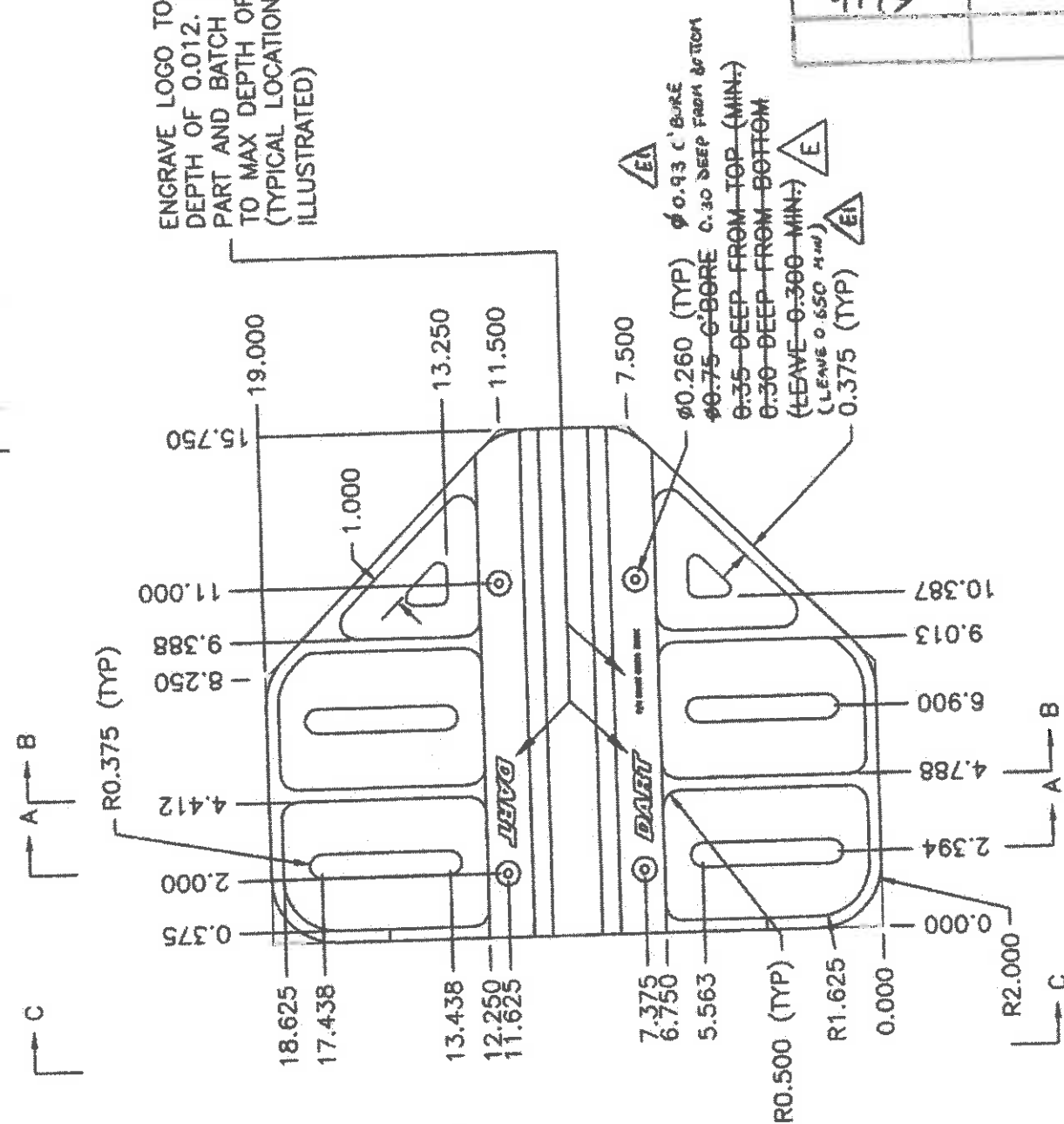
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RELEASE
48.06.17 KE

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

DESIGN KE		DRAWN BY KE		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PP		APPROVED DS		DRAWING NO. D2435	
DATE 98.05.19		TITLE BEARPAW		REV. E SHEET 1 OF 2 SCALE 1:5	
A	96.01.24	NEW ISSUE			
B	96.03.26	CHANGE BORE AND C'BORE DEPTH			
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED			
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)			
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50			

EFFECTIVE	DECD
9143	



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DART AEROSPACE LTD		Work Order:	202737
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010					
B	5.500	+/-0.030					
C	0.200	+/-0.030					
D	R0.250	+/-0.030					
E	0.250	+/-0.010					
F	0.625	+/-0.030					
G	0.25 x 45°	+/-0.030					
H	0.375	+/-0.010					
I	19.000	+/-0.030					
J	0.950	+0.030/-0.010					
K	Ø0.260	+0.005/-0.000					
L	Ø0.930	+/-0.030					
M	0.30	+0.030/-0.000					
N	0.375	+/-0.030					
O	7.375	+/-0.030					
P	4.250	+/-0.010					
Q	2.000	+/-0.030					
R	9.000	+/-0.010					
S	15.750	+/-0.030					

Measured by:		Audited by:		Prototype Approval:	N/A
Date:		Date:		Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	